

Date: Friday, 11/18/2005 5:28:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 24875		
Estimate Number	: 10599		
P.O. Number	: N/A	Part Number	: D2506
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Number	: D2506 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D1
Previous Run	:	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 11/30/2005 Qty: 25 Um: Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est. B 01.06.08 Now laser cut EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 146

Laser Cut per Dwg D2506

Material: AISI 304/316 SS 20 gauge (0.040" thick)

Material release note required

L 05-11-22

2.0	D2506F	Placard
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)

Placard

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206/01/17

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

206-0117

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Form as per dwg D2506

SB 06/01/18 (25)

5.1
 J. 06-01-19
 QCS Inspect work to step 5.0.

J. 06-01-19 25
 Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-19	5	Add QCS after step 5 Permanent change	<i>[Signature]</i>	01-19			<i>[Signature]</i> 06-01-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:28:06 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 24875

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



25
Aug 01 13

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/01/20

(25)

RS 06/01/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No : 0024875
Project Name : D2506
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D2506
Description : Placard
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 11-18-05
Est Finish Date : 12-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 278331 01
Mail To:
WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 8/13/2005 Page: 1

Steel: 304

Finish: 2B

Your Order: P50630PC001V

NAS Order: AE 0322595 03

Corrosion: ASTM A262/02aE, 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
QQS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1.B QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
B36382	* 0574K7 BB	.0360	48.0000	2,820 SHEET	96.000	5	62

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
74K7	.052	18.110	.360	1.642	.304	.064	8.131	.027	.003	.313

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
B36382	0574K7	F T	96.33	50.72	45.54	83.50	88.00

QC ENGINEER

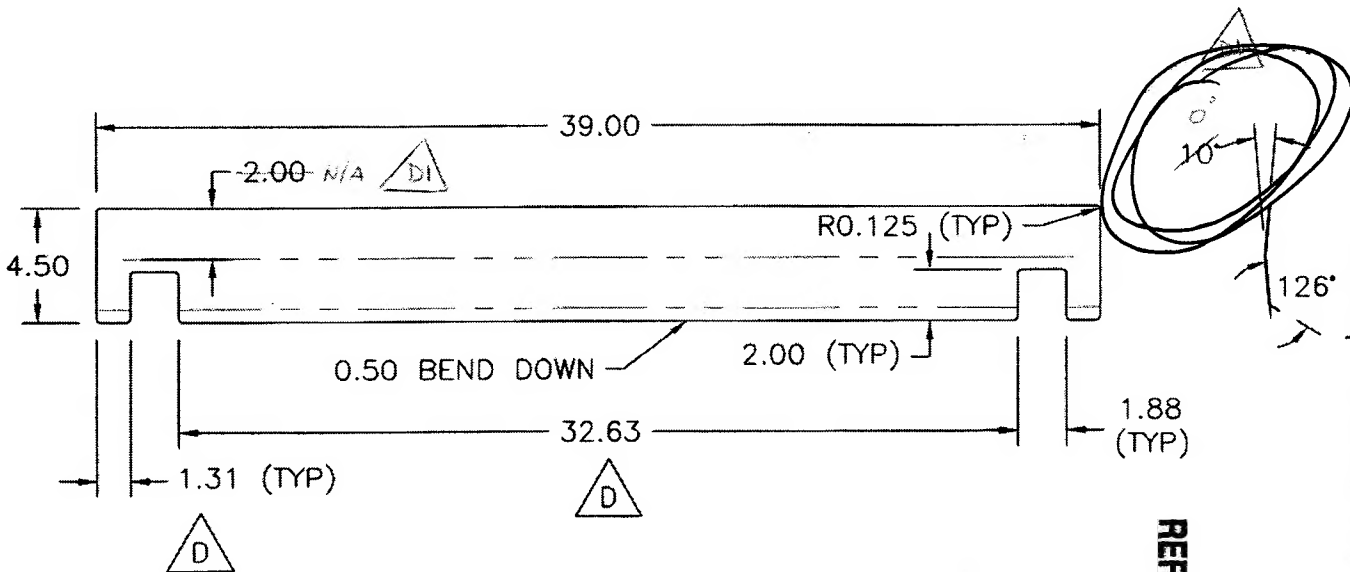
8/13/2005

ERIC HESS



DESIGN	BW	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. 0
DATE	99.10.04	DRAWING NO.	D2506	SHEET 1 OF 1
		TITLE	SCALE	
B		96.06.18	1:7	
C		96.09.04	REDESIGN OF LABEL PLATE	
D		99.10.04	32.63 WAS 32.25, 1.31 WAS 1.50	
D1	<i>[Signature]</i>	04.06.23	0° WAS 10°	

99.10.12 KE



REFERENCE ONLY

D2506 FLAT PATTERN

NOTE: USE R0.08 BEND RADIUS

MATERIAL: AISI 304/316 SS, 0.040 THICK (20 GAUGE)

20.10.04
20.10.04